

Date: Thursday, 9/14/2006 7:27:54 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASSY
Job Number : 28552	
Estimate Number : 10564	
P.O. Number : <u>N/A</u>	Part Number : D34433
This Issue : 9/14/2006 S.O. No. : <u>N/A</u>	Drawing Number : D3443 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 28185	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 10/6/2006 Qty: 4 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: A 05.11.14 New issue EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304R1500



Comment: Qty.: 0.2500 f(s)/Unit Total : 1.0000 f(s)

Batch : M19052

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA588 & DWG D3443

FOLIO REV: AA

DWG REV: B

2-DEBURR AS REQUIRED

[Signature] 06/09/26 10

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 06/09/26 10

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA588 Rev: A & Dwg D3443 Rev: B

2-Deburr per dwg D3443

J.F. 06/10/18 9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3443-3 PAR #: N/A Fault Category: Prod / machine ^{PTB} NCR: Yes No DQA: 2 Date: 06/10/26
 QA: N/C Closed: _____ Date: _____

NCR: <u>28552</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/18	4	The piece move in the chuck, and part is badly damaged.		Scrap, destroy. to replace. Over Qty.	J.F. 06/10/18			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:27:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 28552

Part Number: D34433

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/10/18

9

6.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Drill hole as per Dwg D3443.

70 06/10/25

9

7.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

70 06/10/25

9

8.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

70 06/10/25

9

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 57435

06/10/25 (9)

9

10.0	QC21	FINAL INSPECTION W/O RELEASE
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Comment: FINAL INSPECTION W/O RELEASE

06/10/26 (9)

Job Completion



u 2010.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

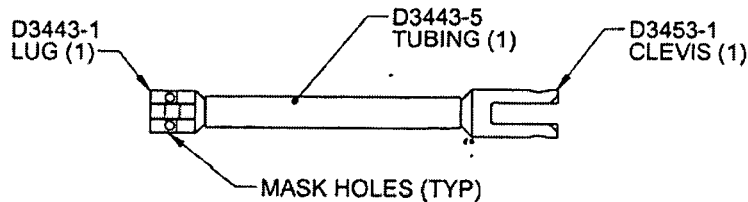
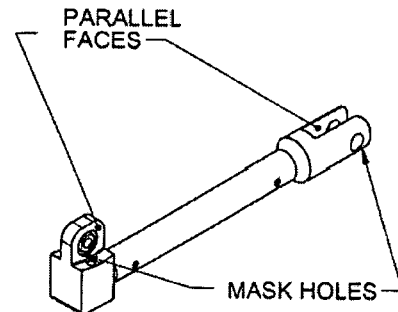
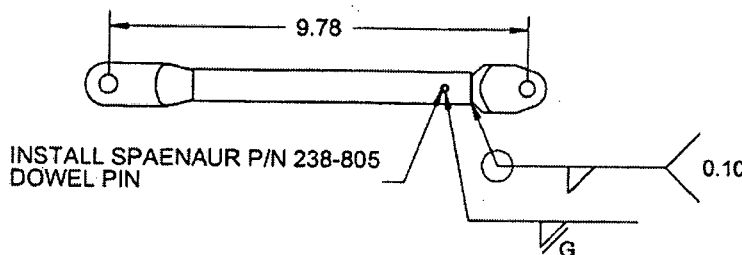
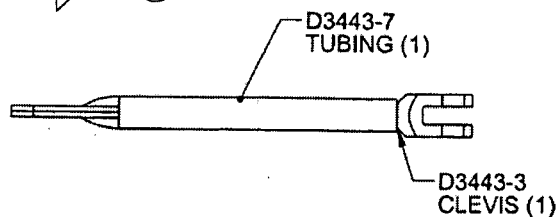
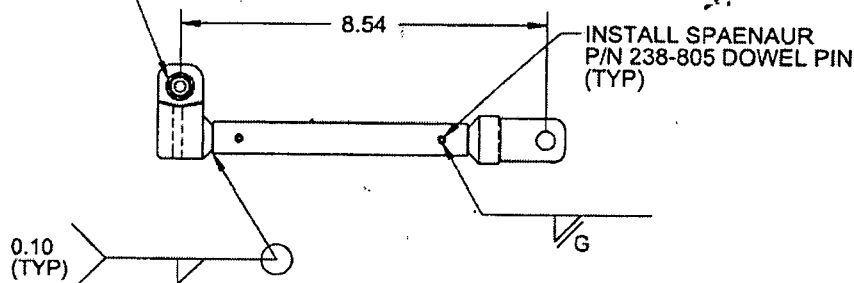
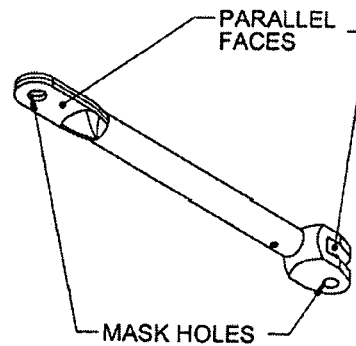
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED

05.12.09 #

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT**D3443-041****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

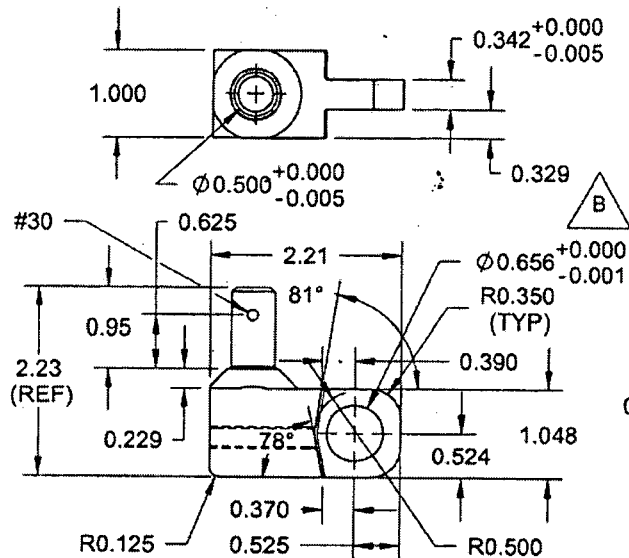
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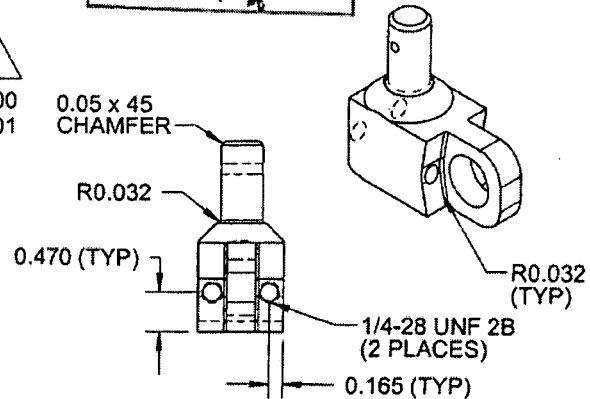
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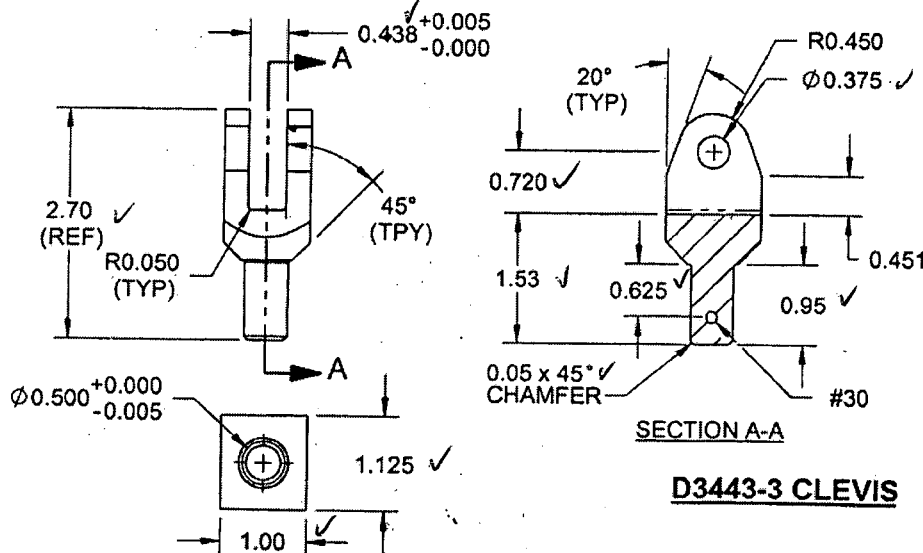
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CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 12		

**RELEASED**

05.12.04 #

**D3443-1 LUG****D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**SECTION A-A****D3443-3 CLEVIS****D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

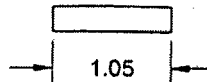
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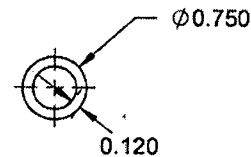
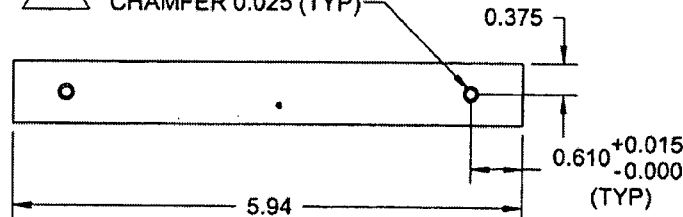
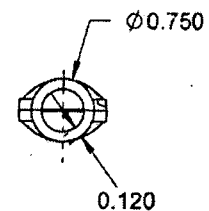
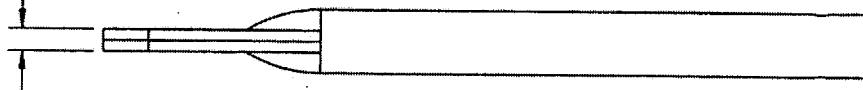
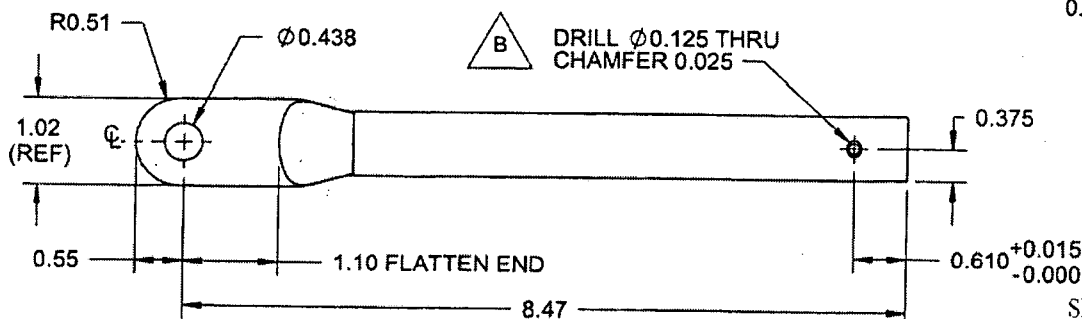
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CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

 $\phi 0.210^{+0.005}_{-0.010}$ **D3443-9 PIN****D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09

DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)**D3443-5 TUBING** $0.260^{+0.000}_{-0.030}$ DRILL $\phi 0.125$ THRU
CHAMFER 0.025**D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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WORK ORDER

NO. 28552

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DART AEROSPACE LTD		Work Order: 28552
Description: Clevis		Part Number: D34433
Inspection Dwg: D3443 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .000$ $\pm .005$.497	✓			
.95	$\pm .030$.942	✓			
2.70	$\pm .030$	2.700	✓			
.05 x 45°	$\pm .030$.05 x 45°	✓			
.438	$\pm .005$ $\pm .000$.438"	✓			
.720	$\pm .010$.728	✓			
1.53	$\pm .030$	1.523	✓			
.625	$\pm .010$.625	✓			
1.00	$\pm .030$	1.004"	✓			
1.125	$\pm .010$	1.131"	✓			
Ø.375	$\pm .006$ $\pm .001$.379"	✓			
Ø.128	$\pm .005$ $\pm .001$.130	✓			
R0.450	$\pm .010$	R0.448"	✓			
.451"	$\pm .010"$.451"	✓			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 04/09/26	Date: 06/10/17	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	